

Work Order ID 131451

Thursday, April 09, 2015 10:53:55 AM

131451

Page 1

Item ID: D2423

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug Extrusion

Stop ***NS2***

Start Date: 5/8/2015 Start Qty: 288.00

288

Cust Item ID:

Required Date: 5/8/2015 Req'd Qty: 288.00

288

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 15/04/09 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2423	Rev B1								

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 28072

Manufacture as per Dwg

Possible Supplier: SIGNATURE ALUMINUM

Material release note is required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

CL 15/04/10 288

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

3/2 F SQ 15-058

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 131451

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131451

Page 2

Item ID: D2423 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Extrusion
Start Date: 5/8/2015 Start Qty: 288.00 ***288*** Cust Item ID:
Required Date: 5/8/2015 Req'd Qty: 288.00 ***288*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:			QTY Effective :				MRB (QSI042) Approval		
Description Work Order Deviation					Disposition					Completed By	
Root Cause					FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
- Misidentified	☐	Past Due	☐								

Picklist Print

Thursday, April 09, 2015 10:53:54 AM

Page 1

Work Order ID: 131451

131451

Parent Item: D2423

D2423

Parent Item Name: Lug Extrusion

Start Date: 5/8/2015

Required Date: 5/8/2015

Start Qty: 288.00

Required Qty: 288.00

Comments: IPP G04.09.02Part Number D2423-108 changed to D2423KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423P		Purchased		No		100	f	0.0000	1	288	312		
D2423P													
Lug Extrusion													

312 Sp15-058

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

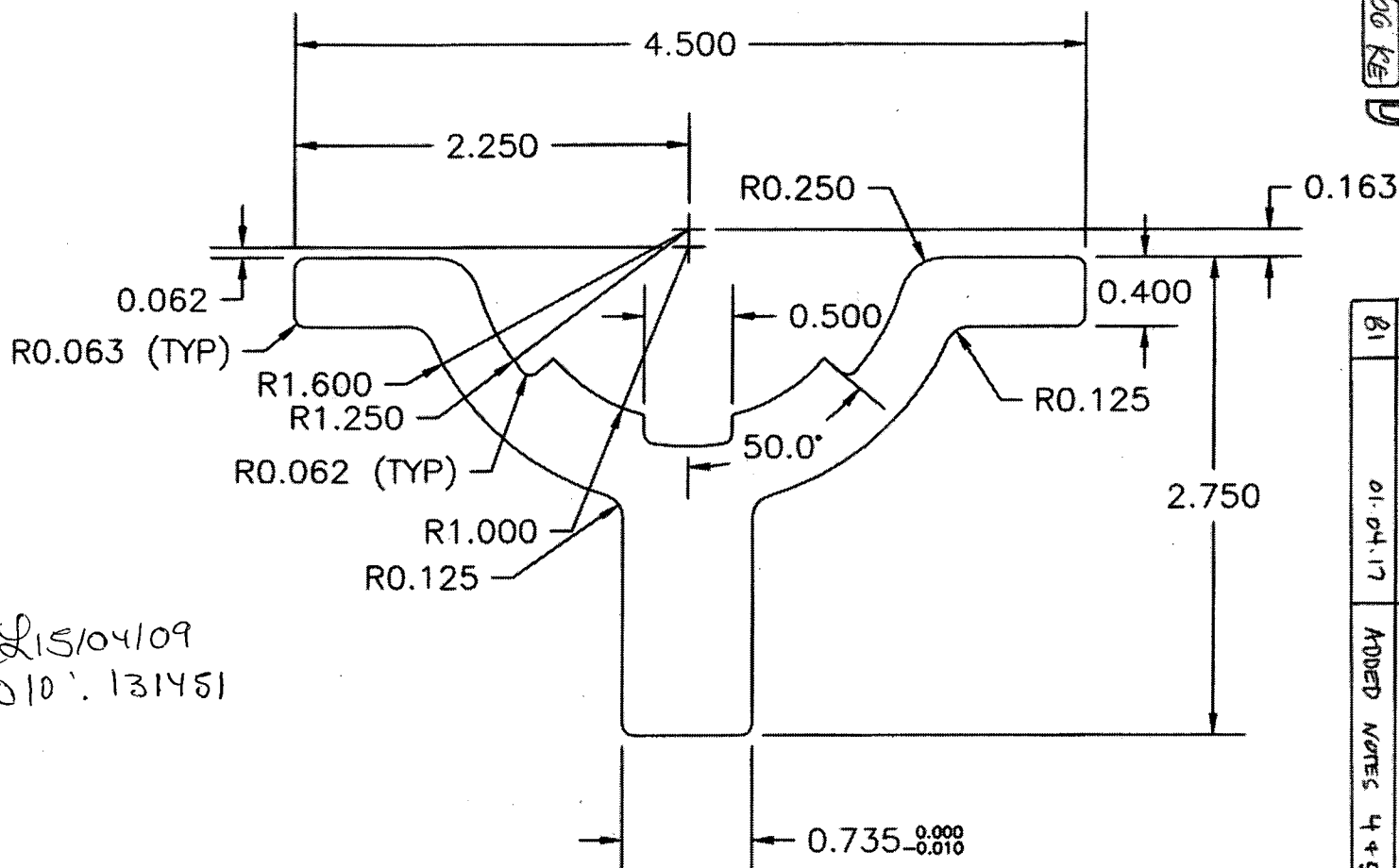
Work Order update only ☐

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RELEASED
98/08/06 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
LE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
98/08/04	98/08/04	D2423
DATE	TITLE	REV. B
98.08.04	LUG EXTRUSION	SHEET 1 OF 1
		SCALE
		1:1
A	95.05.09	NEW ISSUE
B	98.08.04	6061-T6 WAS 6005A.T5
81	01.04.17	ADDED NOTES 4 & 5



CL 15/04/09
W10.131451

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBON INDIALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28072**

Purchase Order Date 4/10/2015

PO Print Date 4/13/2015

Page Number 1 of 2

Order From : VC-BON001

Ship To : DART AEROSPACE LTD

SIGNATURE ALUMINUM CANADA INC.

1270 ABERDEEN

C/O/ T10322C

HAWKESBURY, ON K6A 1K7

P.O. BOX 4488, STN A

CANADA

TORONTO, ON M5W 4H1

CA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone 905-427-6550

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms Net 30

Ship To Phone

Currency CAD

Ship Via: Yours ppd

FOB Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2423P	Lug Extrusion	5/1/2015		288.00	\$12.24	\$3,525.61
			Yes		f		
	NOTE: MATERIAL MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE						
	AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG)						
	B131451		5/1/2015				
	EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS						

Line Total: \$3,525.61

2	71401-45	PROCUREMENT QUALITY CLAUSES	5/1/2015		1.00	\$0.00	\$0.00
			No				
	Procurement Quality Clauses		5/1/2015				
	A005 right of entry						
	A012 chemical and physical test report						
	A016 personnel qualification						
	A017 raw material identification (as applicable)						
	A026 certification of material conformance						
	A041 quality management system						
	A042 dart notification by supplier						
	A043 retention of quality documents						

Note:

4/13/2015



signature
aluminum
CANADA INC

ACCT# 46024

1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU
05-06-15

PACKING LIST NUMBER / N° DE BODEREAU
020326

SALES ORDER NUMBER / N° DE COM
118462

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE

LOCATION

TRAILER NUMBER /
REMORQUE Nombre

SALESMAN /
VENDEUR

CREDIT REP / REP DU CRÉDIT

SALES REP / REP. DES
VENTES

PIC

WILRIDE

042

R. BLAIS

JOB / FICHIER

FIELD SALES REP / REP
REGIONAL DES VENTES

CUST SERVICE REP / REP.
SERVICE CLIENTELE

CUSTOMER ID / ID DU
CLIENT

ORDER DATE / DE LA
COM

CUSTOMER PO NUMBER / CLIENT PO Nombre

PO28072

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

CARRIER / TRANSPORTEUR
WILRIDE

G.ATTENBOROU

M2A

46024

04/10/15

020326

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,140 LB			DAA-5-2	6061 T6		1	1,171	1,149	LB	
	517 KG			D2423P	96.0000 IN			531	521	KG	
	37 PC								39	PC	
Cut(+): 0.1180 Cut(-): 0.0000 Min: -10 % Max: 10 %							850265 / 255511	1	1,171	1,149	39 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 1

1	1,171	1,149	LB
	531	521	KG
		39	PC
TOTALS			

DATE OF DELIVERY

DRIVER



signature
aluminum
CANADA INC.

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
05/01/2015	5354733	118462	1
Cust PO	B/L No	Lot	Date
PO28072	020326	850265	05/06/15

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	1,171 LBS		
Net Qty	1,149 LBS 39 PCS 1 PKGS		
Specification	Die Desc		
AMS QQA 200/8 + ASTM B221			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
313.8 / 45.5	290.4 / 42.1	13.2	N/A	94

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.63	0.26	0.20	0.06	0.86	0.06	0.07	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

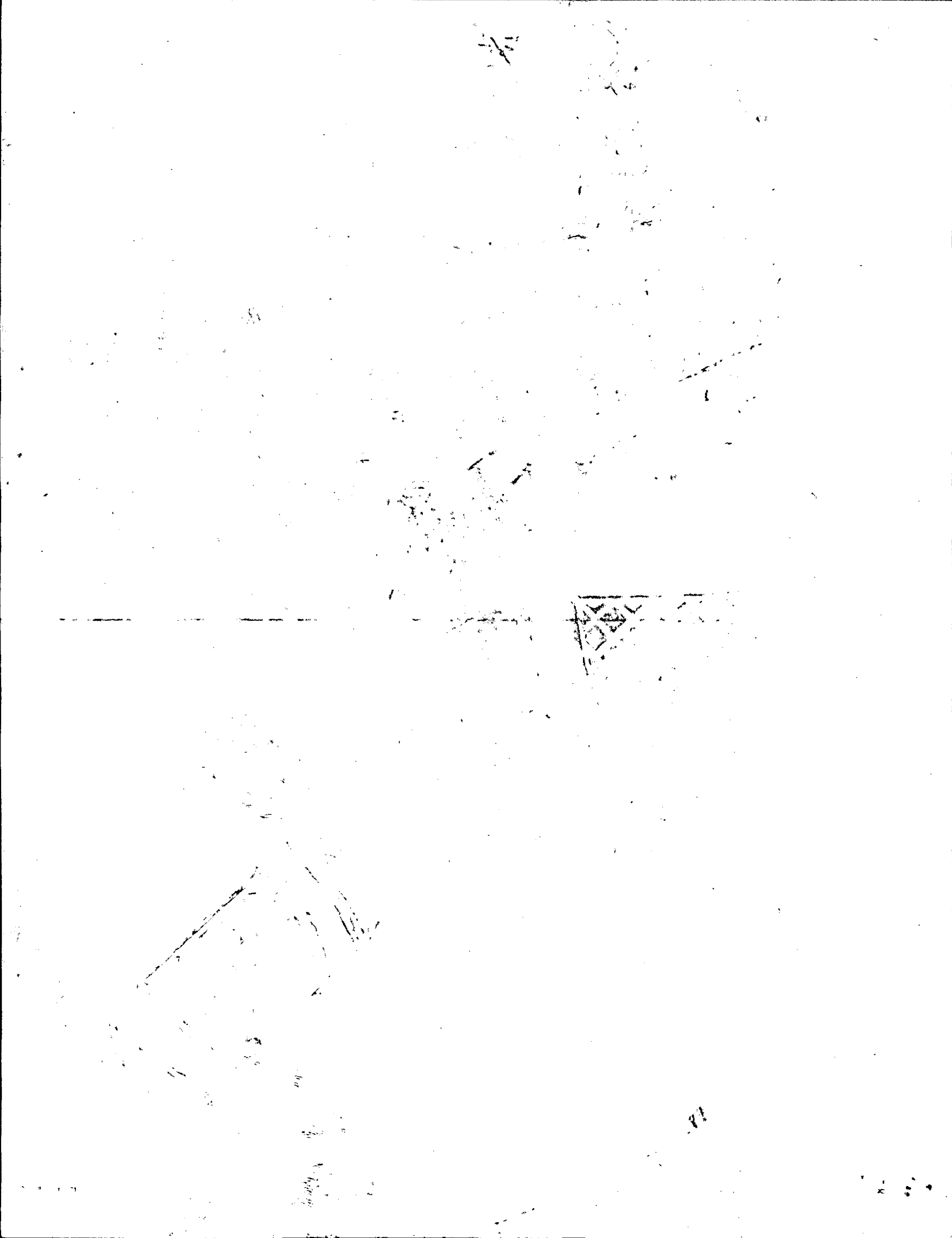
This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc



ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423
DATE: 15-05-19

PO / BATCH NO.: P073012 / 3131451

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 312 ft (39 pcs)
QUANTITY INSPECTED: 39 pcs
QUANTITY REJECTED: 0

THICKNESS ORDERED: N/A
THICKNESS RECEIVED: N/A
SHEET SIZE ORDERED: N/A
SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL	(Y) N	
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT MATERIAL	(Y) N	
CORRECT REF # TO LINK CERT	(Y) N	<u>P073012</u>
CORRECT MATERIAL IDENTIFICATION	(Y) N	<u>tag was put on D2423 3131451</u>
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS 9 9-89</u> DATE: <u>15-05-19</u>		SIGNED OFF BY: _____ DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in